

Work Order ID 131379

Tuesday, April 07, 2015 7:11:10 AM

131379

Page 1

Item ID: D412-630-032 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Pilot/Co-Pilot Folding Step RH - Low, High & Float Gear
 Start Date: 4/7/2015 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 4/7/2015 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: ML5 Date: 1504-07 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr	DAS							
IIN D412-630	N	06 9-89							

100 Document Control 0.00 DAS
100 DOCUMENT CONTROL 02
 DC 9-89
 Doc.Control -USB or Paperwork Memo Photocopy D412-630 bluefile & type labels per PPP412-630-032 CHG003
 SEP 02 2015

110 Small Fab 0.00
110 Small Fab 0.00
 Small Fab Memo Assemble as per IIN D412-630
 ****ensure tension to retract step is 11 to 18 lbs before installing lockwire.****
 A/R MS20995C41 batch: 1131379
 HX 15/07/09

Work Order ID 131379

Tuesday, April 07, 2015 7:11:10 AM

131379

Page 2

Item ID: D412-630-032

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Pilot/Co-Pilot Folding Step RH - Low, High & Float Gear

Start Date: 4/7/2015 Start Qty: 4.00 ***4***

Cust Item ID:

Required Date: 4/7/2015 Req'd Qty: 4.00 ***4***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							DAS 38 9-89
120									
QC	Memo	0.00							
Quality Control	****ensure tension to retract step is 11 to 18 lbs **** Test fit on aircraft in Eng. lab. DAS 38 9-89 ENSURE STEP IS A.H. 9-89 RH								JUL 09 2015
130	Pick Kit	0.00							
130									
Packaging	Memo	0.00							
Packaging									JUL 22 2015 DAS 02 9-89
140	QC4- 100% Inspect kits for completeness	0.00							
140									
QC	Memo	0.00							
Quality Control									DAS 02 9-89

SEP 02 2015

Work Order ID 131379***131379***

Page 3

Tuesday, April 07, 2015 7:11:10 AM

Item ID: D412-630-032

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Pilot/Co-Pilot Folding Step RH - Low, High & Float Gear

Start Date: 4/7/2015 Start Qty: 4.00 ***4***

Cust Item ID:

Required Date: 4/7/2015 Req'd Qty: 4.00 ***4***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Packaging	0.00				4			DAS 02 9-89
150									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-630-032								
	ENSURE STEP IS A RH: _____								
	Location: 034								
	PPP Rev: _____								
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

SEP 02 2015

34 20150903

Picklist Print

Tuesday, April 07, 2015 7:11:14 AM

Page 1

Work Order ID: 131379

131379

Parent Item: D412-630-032

D412-630-032

Parent Item Name: Pilot/Co-Pilot Folding Step RH - Low, High & Float Gear

Start Date: 4/7/2015

Required Date: 4/7/2015

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV. A 05.11.21 NEW ISSUE EC
IPP REV. B 05.12.19 updated pick list EC
IPP REV. C 07.11.12 ecn 1019, nochg EC verified by: DD IPP Rev: D
10.05.28 added route seq DD verf: EC IPP Rev: E 11.06.01
removed qty1 an310-4 EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN310-4		Purchased	No			110	Each	94.0000	1	4			APR 07 2015
---------	--	-----------	----	--	--	-----	------	---------	---	---	--	--	-------------

AN310-4

Nut

**

132382x4

DAS
03
9-89

Location

Loc Qty

Loc Code

GA	25	
M127815	25	
ST331	69	
M129913	68	
M131320	1	

MS24665-302

Purchased No

110 Each 97.0000 1 4

MS24665-302

Cotter Pin

**

Location

Loc Qty

Loc Code

GA	36	
120521	36	
ST293	61	
116396	1	
m127305	60	

DAS
03
9-89

AN310-5

Purchased No

130 Each 68.0000 2 8

AN310-5

Nut

**

JA

JUL 23 2015

DAS
03
9-89

Location

Loc Qty

Loc Code

ST331	68	
m129706	18	
m131320	50	

DAS
02
9-89

8

Picklist Print

Tuesday, April 07, 2015 7:11:14 AM

Work Order ID: 131379

131379

Parent Item: D412-630-032

D412-630-032

Parent Item Name: Pilot/Co-Pilot Folding Step RH - Low, High & Float Gear

Start Date: 4/7/2015

Required Date: 4/7/2015

Start Qty: 4.00

Required Qty: 4.00

AN3C5A

Purchased

No

130

Each

1,183.000

3

12

AN3C5A

Bolt

**

JA

DAS
02
9-89

DAS
02
9-89

Location

Loc Qty

Loc Code

FG

5

122800

5

FP001

8

M131420

8

ST338a

826

M130770

10

M130851

16

M131803

800

ST350

344

M131320

344

m132640

130

Each

15.0000

1

4

AN44-C12

Purchased

No

AN44-C12

Eye Bolt

**

JA

DAS
02
9-89

DAS
02
9-89

Location

Loc Qty

Loc Code

FG

3

124829

3

ST339

12

M126293

12

4

AN4C15

Purchased

No

130

Each

54.0000

1

4

AN4C15

Bolt

**

JA

JUL 22 2015

DAS
02
9-89

DAS
02
9-89

Location

Loc Qty

Loc Code

ST312A

49

M128936

49

4

ST343

5

M128634

5

Picklist Print

Tuesday, April 07, 2015 7:11:14 AM

Page 3

Work Order ID: 131379

131379

Parent Item: D412-630-032

D412-630-032

Parent Item Name: Pilot/Co-Pilot Folding Step RH - Low, High & Float Gear

Start Date: 4/7/2015

Required Date: 4/7/2015

Start Qty: 4.00

Required Qty: 4.00

AN5C11

Purchased No

130

Each

10.0000

1

4

AN5C11

BOLT

DAS
02
9-89

Location

Loc Qty

Loc Code

ST338

10

M128773

10

4

AN5C15

Purchased No

130

Each

15.0000

1

4

AN5C15

BOLT

DAS
02
9-89

Location

Loc Qty

Loc Code

ST337

15

M126012

1

M129934

14

4

D3454-1

Manufactured No

130

Each

11.0000

1

4

D3454-1

Bushing

DAS
02
9-89

Location

Loc Qty

Loc Code

ST039

11

108642

11

4

D3454-3

Manufactured No

130

Each

66.0000

2

8

D3454-3

Bushing

DAS
02
9-89

Location

Loc Qty

Loc Code

ST039

66

121223

66

8

Tuesday, April 07, 2015 7:11:14 AM

Shop Packet Print

Page 3

Picklist Print

Tuesday, April 07, 2015 7:11:14 AM

Page 4

Work Order ID: 131379

131379

Parent Item: D412-630-032

D412-630-032

Parent Item Name: Pilot/Co-Pilot Folding Step RH - Low, High & Float Gear

Start Date: 4/7/2015

Required Date: 4/7/2015

Start Qty: 4.00

Required Qty: 4.00

D3454-5

Manufactured No

130

Each

21.0000

2

8

D3454-5

Bushing

DAS
02
9-89

Location

Loc Qty

Loc Code

ST040

21

121224

21

**

JA

D3455-1

Manufactured No

130

Each

17.0000

4

16

D3455-1

Spacer

DAS
02
9-89

Location

Loc Qty

Loc Code

ST040

17

127825

17

D3455-3

Manufactured No

130

Each

17.0000

2

11

8

D3455-3

Spacer

DAS
02
9-89

Location

Loc Qty

Loc Code

ST040

17

121684

17

D3462-042

Manufactured No

130

Each

1.0000

1

4

D3462-042

Bracket Assembly

DAS
02
9-89

Location

Loc Qty

Loc Code

st541

1

121656

1

**

JA

JUL 22 2015

B125838

3

Picklist Print

Tuesday, April 07, 2015 7:11:14 AM

Page 5

Work Order ID: 131379

131379

Parent Item: D412-630-032

D412-630-032

Parent Item Name: Pilot/Co-Pilot Folding Step RH - Low, High & Float Gear

Start Date: 4/7/2015

Required Date: 4/7/2015

Start Qty: 4.00

Required Qty: 4.00

MS21043-3

Purchased No

130

Each

1,098.000

3

12

MS21043-3

Nut

**

JA

DAS
6
9-89

DAS
02
9-89

Location

Loc Qty

Loc Code

FG	80
103691	80
FP001	104
m130673	104
GA	397
m130673	15
m131677	382
ST304	517
m131340	517

15/09/02

x1

x 12 8

**

JA

DAS
6
9-89

MS24665-227

Purchased No

m132551

130

Each

175.0000

MS24665-227

Cotter Pin

DAS
02
9-89

Location

Loc Qty

Loc Code

GA	16
111041	16
ST293	159
m127837	159

P

NAS1149C0363R

Purchased No

130

Each

664.0000

7

28

NAS1149C0363R

Washer

**

JA

JUL 22 2015

DAS
6
9-89

DAS
02
9-89

Location

Loc Qty

Loc Code

FP001	102
114742	102
GA	180
m130673	180
ST271	382
m130673	382

28

Tuesday, April 07, 2015 7:11:14 AM

Shop Packet Print

Page 5

Picklist Print

Tuesday, April 07, 2015 7:11:14 AM

Page 6

Work Order ID: 131379

131379

Parent Item: D412-630-032

D412-630-032

Parent Item Name: Pilot/Co-Pilot Folding Step RH - Low, High & Float Gear

Start Date: 4/7/2015

Required Date: 4/7/2015

Start Qty: 4.00

Required Qty: 4.00

NAS1149C0563R

Purchased

No

130

Each

791.0000

1

4

NAS1149C0563R

Washer

DAS
02
9-89

Location

Loc Qty

Loc Code

ST260a

500

m131697

500

ST271

291

m131026

291

**

JA

JUL 22 2015

DAS
02
9-89

NAS1515H5

Purchased

No

130

Each

245.0000

1

4

NAS1515H5

Washer

DAS
02
9-89

Location

Loc Qty

Loc Code

FG

40

103691

40

ST266

205

125574

5

m130783

200

**

JA

JUL 22 2015

DAS
02
9-89

D3455-1

Manufactured

No

110

Each

17.0000

2

8

D3455-1

Spacer

**

APR 07 2015

DAS
02
9-89

Location

Loc Qty

Loc Code

ST040

17

127825

17

110

Each

6.0000

1

4

D3443-041

Manufactured

No

D3443-041

Sirut Weldment Assembly

**

2X

15/07/09

DAS
02
9-89

Location

Loc Qty

Loc Code

st541

6

125854

2

127760

4

2

3131603
20

Tuesday, April 07, 2015 7:11:14 AM

Shop Packet Print

Page 6

Picklist Print

Tuesday, April 07, 2015 7:11:14 AM

Page 7

Work Order ID: 131379

131379

Parent Item: D412-630-032

D412-630-032

Parent Item Name: Pilot/Co-Pilot Folding Step RH - Low, High & Float Gear

Start Date: 4/7/2015

Required Date: 4/7/2015

Start Qty: 4.00

Required Qty: 4.00

D3463-042	Manufactured	No	110	Each	0.0000	1	4	DAS
D3463-042								CS
Step Weldment Assembly								9-89

D3443-9	Manufactured	No	110	Each	22.0000	2	8	
D3443-9								DAS
Pin								CS

Location	Loc Qty	Loc Code
ST039	22	
109100	2	
125737	20	

AN4C14	Purchased	No	110	Each	23.0000	1	4	DAS
AN4C14								CS
Bolt								9-89

Location	Loc Qty	Loc Code
ST344	23	
m126461	4	
m131264	19	

MS24665-229	Purchased	No	130	Each	13.0000	2	8	DAS
MS24665-229								CS
Cotter Pin								9-89

DAS
02
9-89

Location	Loc Qty	Loc Code
GA	13	
118234	13	

MS24665-227	Purchased	No	110	Each	175.0000	1	8 4	DAS
MS24665-227								CS
Cotter Pin								9-89

Location	Loc Qty	Loc Code
GA	16	
111041	16	
ST293	159	
m127831	159	

Tuesday, April 07, 2015 7:11:14 AM

Shop Packet Print

Page 7

JUL 22 2015
JA
APR 07 2015

Picklist Print

Tuesday, April 07, 2015 7:11:14 AM

Page 8

Work Order ID: 131379

131379

Parent Item: D412-630-032

D412-630-032

Parent Item Name: Pilot/Co-Pilot Folding Step RH - Low, High & Float Gear

Start Date: 4/7/2015

Required Date: 4/7/2015

Start Qty: 4.00

Required Qty: 4.00

AN4CH3

Purchased No

110 Each

25.0000

2 8

AN4CH3

Bolt

**

DAS
C3
9-89

Location

Loc Qty

Loc Code

ST346

25

M126085

25

D3465-1

Manufactured No

110 Each

21.0000

1

4

D3465-1

Washer

**

DAS
C3
9-89

Location

Loc Qty

Loc Code

ST040

21

121476

21

AN310-4

Purchased No

130 Each

94.0000

1

AN310-4

Nut

**

J.A

JUL 2 2 2015

DAS
02
9-89

Location

Loc Qty

Loc Code

GA

25

M127815

25

ST331

69

~~M129913~~ M129913

68

M131320

1

M132382

D3443-043

Manufactured No

110 Each

6.0000

1

4

D3443-043

Strut Weldment Assembly

**

121217 J.

APR 07 2015

Location

Loc Qty

Loc Code

st541

6

121217

6

~~M129913~~

M132382

DAS
C3
9-89

DAS
36
9-89

Tuesday, April 07, 2015 7:11:14 AM

Shop Packet Print

Page 8

Picklist Print

Tuesday, April 07, 2015 7:11:14 AM

Page 9

Work Order ID: 131379

131379

Parent Item: D412-630-032

D412-630-032

Parent Item Name: Pilot/Co-Pilot Folding Step RH - Low, High & Float Gear

Start Date: 4/7/2015

Required Date: 4/7/2015

Start Qty: 4.00

Required Qty: 4.00

D3454-7

Manufactured No

110

Each

16.0000

2

8

DAS

D3454-7

Bushing

6
9-89

Location

Loc Qty

Loc Code

ST040

16

121225

16

8

AN310-7

Purchased

No

110

Each

86.0000

1

4

AN310-7

Nut

DAS

Location

Loc Qty

Loc Code

ST331

86

124198

46

m120124

40

4

6
9-89

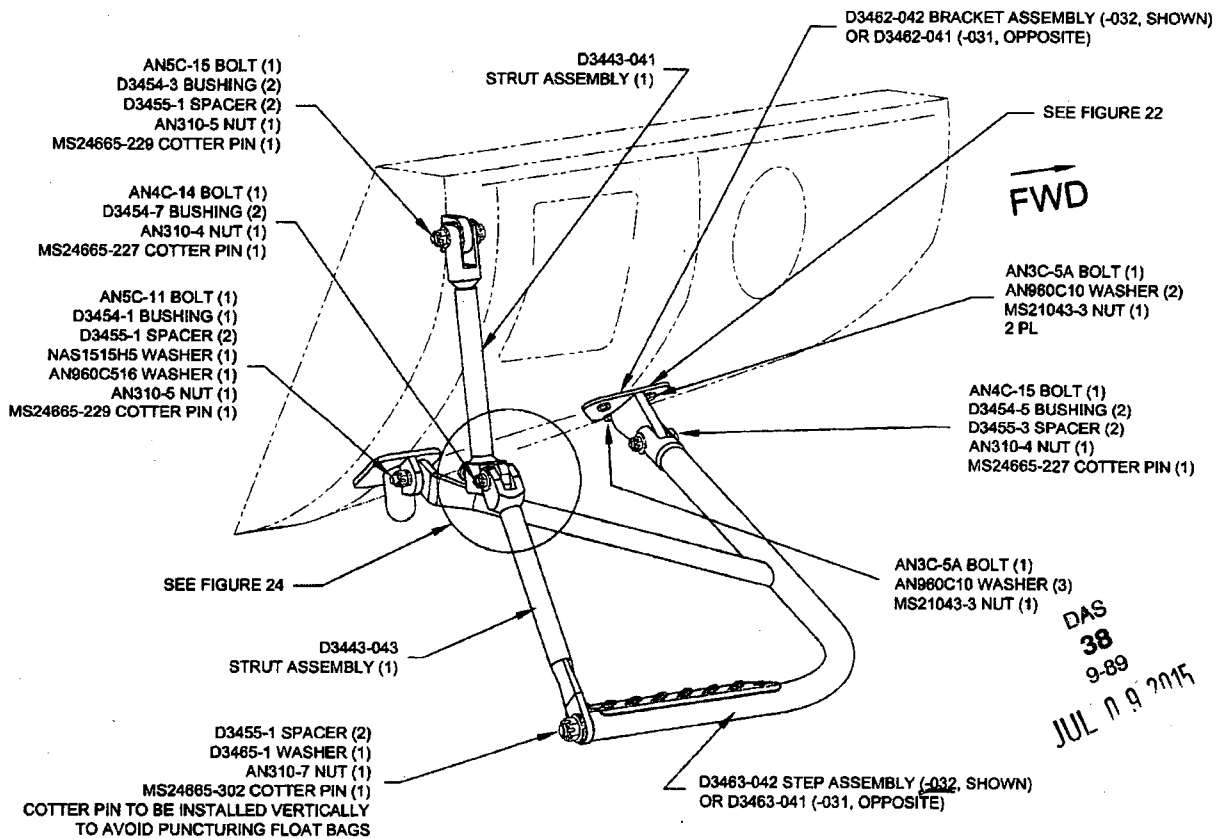


FIGURE 23 – Isometric View D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)
D412-630-031 LH (Opposite)

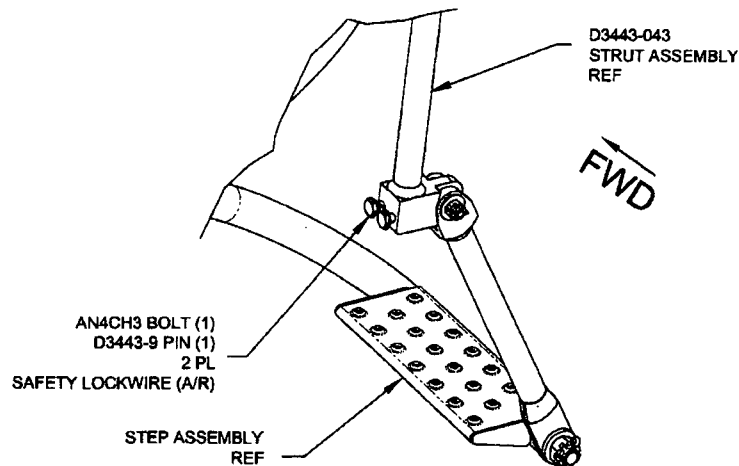


FIGURE 24 – Detail Safety Wiring, D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)
D412-630-031 LH (Opposite)

• COPYRIGHT © 1996 BY DART AEROSPACE LTD. •
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: N
Date: 13.09.18

Qty -031	Qty -032	Part Number	Description
X		D412-630-031	PILOT/CO-PILOT STEP, LH (FOLDING)
	X	D412-630-032	PILOT/CO-PILOT STEP, RH (FOLDING)
1	1	D3443-041	STRUT ASSEMBLY
1	1	D3443-043	STRUT ASSEMBLY
2	2	D3443-9	PIN
1	1	D3454-1	BUSHING
2	2	D3454-3	BUSHING
2	2	D3454-5	BUSHING
2	2	D3454-7	BUSHING
6	6	D3455-1	SPACER
2	2	D3455-3	SPACER
1		D3462-041	BRACKET ASSEMBLY
	1	D3462-042	BRACKET ASSEMBLY
1		D3463-041	STEP ASSEMBLY
	1	D3463-042	STEP ASSEMBLY
1	1	D3465-1	WASHER
2	2	AN310-4	NUT
2	2	AN310-5	NUT
1	1	AN310-7	NUT
3	3	AN3C-5A	BOLT
1	1	AN44-C12	* EYEBOLT
1	1	AN4C14	BOLT
1	1	AN4C15	BOLT
2	2	AN4CH3	BOLT
1	1	AN5C11	BOLT
1	1	AN5C15	BOLT
7	7	AN960C10	WASHER
1	1	AN960C516	WASHER
3	3	MS21043-3	NUT
2	2	MS24665-227	COTTER PIN
2	2	MS24665-229	COTTER PIN
1	1	MS24665-302	COTTER PIN
1	1	NAS1515H5	WASHER

* USE AN44-C12 EYEBOLT WHEN D412-630-031/-032 IS INSTALLED IN CONJUNCTION WITH D412-630-023/-024/-033/-034TM HELI-ACCESS-STEP

Work Order ID 131379

Tuesday, April 07, 2015 7:11:10 AM

131379

Page 1

Item ID: D412-630-032

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Pilot/Co-Pilot Folding Step RH - Low, High & Float Gear

Start Date: 4/7/2015 Start Qty: 4.00 ***4***

Cust Item ID:

Required Date: 4/7/2015 Req'd Qty: 4.00 ***4***

Customer:

Reference:

Approvals: Process Plan: MCS Date: 1504-07 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

IIN D412-630	N
--------------	---

DAS

9-89

9-89

100

Document Control

0.00

100

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy D412-630 bluefile & type labels per PPP412-630-032 CHG003

MCS JUL 22 2015

4

110

0.00

110

Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble as per IIN D412-630

ensure tension to retract step is 11 to 18 lbs before installing lockwire.

A/R MS20995C41 batch: M131379

4X

15/07/09

DAS
3E
9-8